



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-341BL
Job Sheet 201763



Part No: D206-642-341BL

Job Qty: 1 pcs

Part Name: Replacement Skidtube (Fits LH or RH)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/19

Job Tracking No:

Due Date: 10/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2650 REV.F(DEO) IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC ver: DD IPP Rev: L 12.11.22 now swage per ecn12-679 DD ver: JLM IPP Rev: M 14.04.25 ECN14-520 DD ver: JLM IPP REV: N 15.10.09 ADDED BL DD VERF: JLM IPP REV: O 16.01.22 PAR16-484 DD VERF: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skid tubes - 1	1 pcs	10/25/19		0.00	1.58	Skid tubes - 1		
							Skid tubes - 2		
							Skid tubes - 3		
							Skid tubes - 4		
							Skid tubes - 5		
							Skid tubes - 6		
							Skid tubes - 7		
115	QC 5	1 pcs	10/25/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
116	QC 9	1 pcs	10/25/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		



Container No: S228343



Part: D206-642-341BL

Job No: 201763

Serial No/Batch: S228343

Revision: F(deo)

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 19/10/17, TC STC SH98-

Dart Aerospace Ltd.
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CANADA
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10/17/2019

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					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	<i>A</i>
					QC 9 - 9	
120	Handfinish - 1-1 Chemical-B4B	1	10/25/19	0.00 1.17	Handfinish - 1 - 1 - B4B	<i>BEB 19-11-05</i>
	pcs				Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
125	QC 7	1	10/25/19	0.00 0.00	QC 7 - 10	
	pcs				QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	

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					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	DO
130 Skidtubes - 2 - B4B	1	10/25/19	0.00 1.58		Skidtubes - 1 - B4B	DO
pcs					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	BL
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
140 QC 5	1	10/25/19	0.00 0.00		QC 5 - 10	
pcs					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BL
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150 Skidtubes - 3 - B4B	1	10/25/19	0.00 1.58		Skidtubes - 1 - B4B	
pcs					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	TF
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
180 QC 5	1	10/25/19	0.00 0.00		QC 5 - 10	
pcs					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	

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190 Handfinish - 2-1 Pressure-B4B	1 pcs	10/25/19	0.00 1.17	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 2 - 1 - B4B	BEB 19-11-11
208 Spray Paint - 2 - B4B	1 pcs	10/25/19	0.00 1.00	Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
				Spray Paint - 1 - B4B	DAS 4 NOV 12 2019 3-89
210 QC 14	1 pcs	10/25/19	0.00 0.00	Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
				QC 14 - 15	14 19-11-13
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
220 Handfinish - 4-1-Assembly-B4B	1 pcs	10/25/19	0.00 1.17	QC 14 - 61	
				QC 14 - 81	
				Handfinish - 4 - 1 - B4B	14 19-11-13
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
240 QC 5	1 pcs	10/25/19	0.00 0.00	Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS NOV 14 2019 3-89

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					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
250	Packaging 3-1 - Stock - B4B	1	10/25/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	DAS
					Packaging 3 - 26 - B4B	78 NOV 15 2019
					Packaging 3 - 27 - B4B	9-89
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS
255	DC - 1 - B4B	1	10/25/19	0.00 0.00	DC - 1 - B4B	21
	pcs				DC - 2 - B4B	NOV 15 2019
260	QC 21 - FG	1	10/25/19	0.00 0.00	QC 21 - FG - 21	DAS
	pcs				QC 21 - FG - 70	NOV 15 2019
					QC 21 - FG - 53	21
Part Op 110 - Skidtubes 1-Deburr Fwd edge of tube 2-Scribe "Identify Batch Number" 3-Remove ridge on inside of Fwd edge of Descriptions: tubeas per Dwg D2650 4-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R Aluminum Rod 136169/14704 5-Grind weld flush to cap on top surface only. 6-Cut aft end to length as per dwg D2650 7-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. 8-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297". 9-Open Aft Cap Hole using #6 Drill Bit 10-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail 11-Remove inner indexing ridge on aft end of skidtubes per Dwg D2650 12- Ream holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 13-Deburr. 115 - QC5- Inspect part completeness to step on W/O 116 - QC9- Inspect visual per QSI004- Fusion Welds 120 - Chemical Conversion Coat per QSI005 4.1 125 - QC7-Inspect Chemical Conversion Coat 130 - Skidtubes - 1- Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting Start Date: 5/20/2020 Time: 07:25:20 Finish Date: A/R Sikaflex-291 140 - QC5- Inspect part completeness to step on W/O						

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- 150 - Skidtubes - 1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002
 180 - QC5- Inspect part completeness to step on W/O
 190 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
 208 - Prime and Paint DELFLEET BLUE as per QSI005 *Primer 5171337 Blue 5187836 clear 5173357*
 210 - QC14- Inspect Spray Paint
 220 - HandFinish4 (Assemble as per dwg - 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/R Sikaflex-291 *5163334* Sikaflex expiry date: *11-12-14* 2- Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive 3-Install MS27039-4-06 Screw 4-Inspect for foreign object per QSI 024 5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/R Sikaflex-291 *5163334* Sikaflex expiry date: *11-12-14* 6- Install D2680-041 Nut Plate as per Dwg D2650 7-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: *5204362*
 240 - QC5- Inspect part completeness to step on W/O
 250 - Identify and pack for shipping as per PPP D206-642-341 Location:FG083
 255 - Document Control - Photocopy bluefile and create labels per PPP D206-642-341 CHG005
 260 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 pcs (1 ea)	110-Skidtubes - 1	<i>520317</i>
D2647	Cap	1 pcs (1 ea)	110-Skidtubes - 1	<i>5166098</i>
D2654-5	Web	1 pcs (1 ea)	130-Skidtubes - 2 - B4B	<i>5220149</i>
D4720-1	Spacer	<i>20</i> 19 pcs (19 ea)	150-Skidtubes - 3 - B4B	<i>524318</i>
ALS4-1032-130	Rivnut	54 Ea (54 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5053257</i>
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5226154</i>
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5163230-2</i>
D2646BL	Aft Cap	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5173722</i>
D2651-1BL	Plug	14 pcs (14 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5167942</i>
D2651-3	O-Ring	14 pcs (14 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5180320</i>
D2680-041BL	Nut Plate	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5169112</i>
D3537-1	Wearpad	6 pcs (6 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5275791</i>
D3537-3	Wearpad	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5218982</i>
D4956-11	Wearplate Fwd	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5210716</i>
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5210724</i>
D4956-35	Wearplate Aft	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5209487</i>
MS27039-1-08	Screw	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5162897</i>
MS27039-4-06	Screw	1 Ea (1 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5166774-5</i>
MS27039C1-08	Screw	54 Ea (54 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5218052</i>
NAS1149C0332R	Washer (AN960C10L)	54 Ea (54 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5218161</i>
NAS1149D0332J	Washer	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5178374</i>
NAS1149D0463J	Washer	1 Ea (1 ea)	220-Handfinish - 4-1-Assembly-B4B	<i>5158585</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	15	0
	D2647	1	20	0
130-Skidtubes - 2 - B4B	D2654-5	1	7	0
150-Skidtubes - 3 - B4B	D4720-1	19	23	0
220-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	54	5,510	0
	CCR264SS3-3	2	35	0
	CR3212-4-03	2	130	0
	D2646BL	1	1	0
	D2651-1BL	14	38	0
	D2651-3	14	553	0
	D2680-041BL	1	17	0
	D3537-1	6	74	0
	D3537-3	1	25	0
	D4956-11	1	8	0
	D4956-23	1	11	0
	D4956-35	1	16	0
	MS27039-1-08	2	172	0
	MS27039-4-06	1	224	0
	MS27039C1-08	54	339	0
	NAS1149C0332R	54	3,507	0
	NAS1149D0332J	2	1,554	0
	NAS1149D0463J	1	1,888	0

Part Specifications
Specifications could not be found.

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Entered: _____ Date: _____

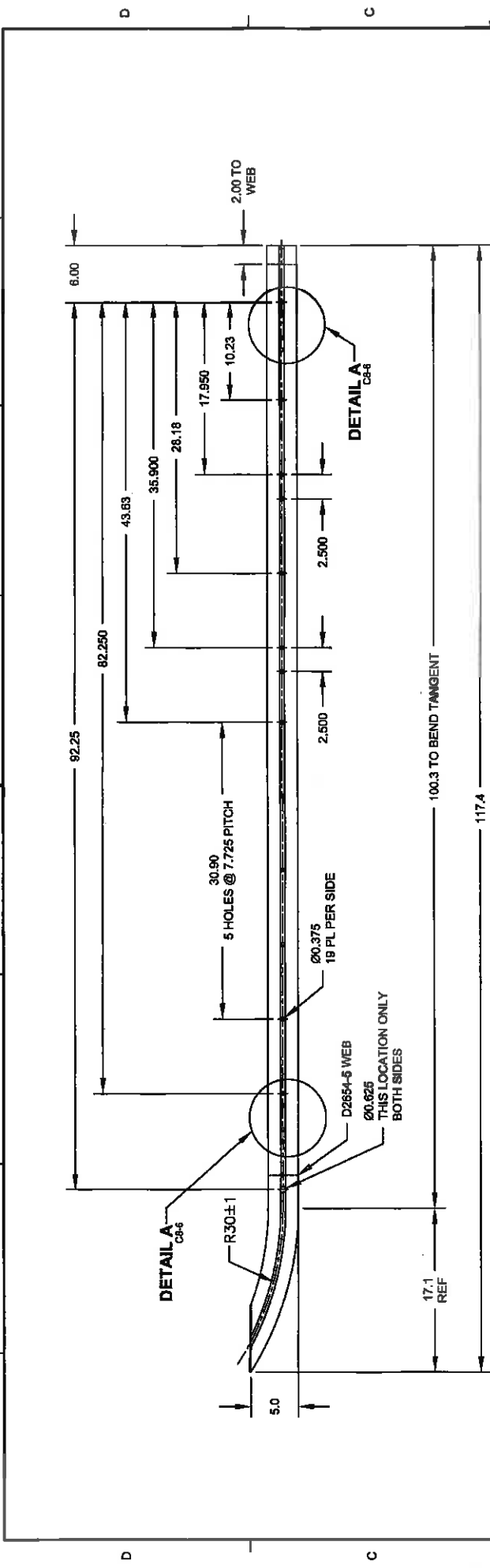
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

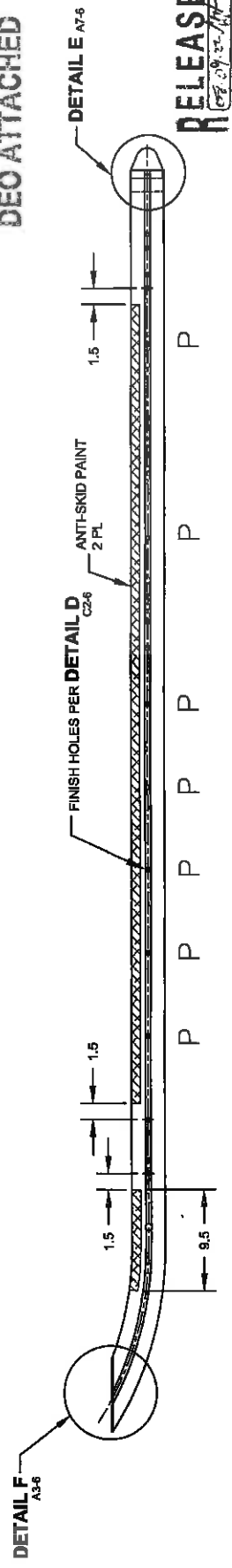
DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☒ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐
Date: 19/10/30	Sequence #: _____	QTY Affected: _____		MRB (Q51042) NSP 12 19/10/30	
Description Work Order Deviation		Disposition			
Dwg calls for $\phi 0.625$ tan ring hole which is too small for tan ring		Drill tan ring hole $\phi 0.640$ Ref. D3274 Rev. G			
Completed By TF		Lead hand / Supervisor			
QC / QA Coordinator					
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				

1 2 3 4 5 6 7 8



D2650-5 BENDING/DRILLING DETAIL

DEO ATTACHED



D2650-5 ASSEMBLY/FINISHING DETAIL

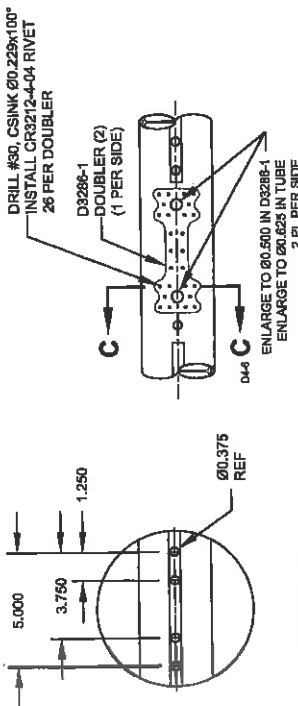
DESIGN	DS	DART AEROSPACE USA, INC
DRAWN	A/S	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. F
MFG. APPR.		D2650 SHEET 4 OF 8
APPROVED		TITLE SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES NTS
DATE	08.08.08	

RELEASED

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1 2 3 4 5 6 7 8

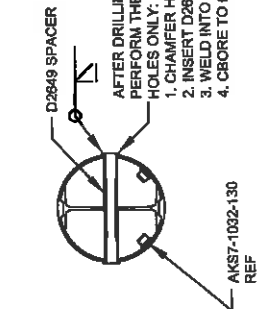
SECTION C-C C7-8
SCALE NONE



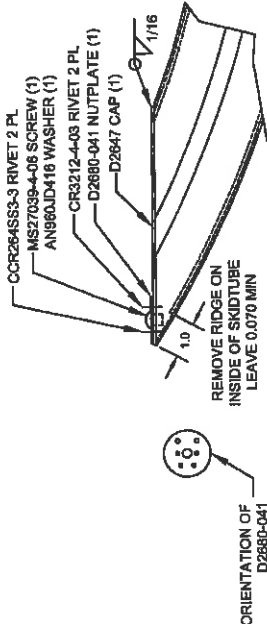
DETAIL A C2-2
SCALE 2X D7-2 D7-3 D7-4 D7-5 D8-5

DETAIL B C3-2 C3-3
SCALE 2X

- TO INSTALL D3286-1/2:
1. GRIND OFF FLANGE IN AREA SHOWN, FINISH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.

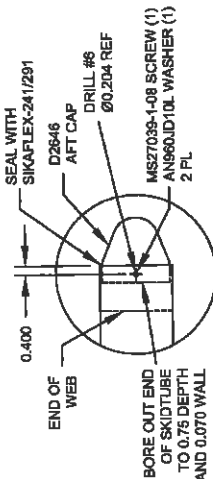


DETAIL D B4-2 B4-3 B4-4 B4-5
FOR Ø0.375 HOLES ONLY
SCALE 3X



- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2847 (TRIM AS NECESSARY)
 4. WELD D2847 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2880-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2880-041 PRIOR TO FINISH

DETAIL E B2-2 B2-3 B1-4 B1-5
SCALE 2X



DETAIL F B9-2 B9-3 B9-4 B9-5
SCALE NONE

RELEASED
R 08-09-22-183
DEO ATTACHED

DESIGN	DS	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN	AJS		
CHECKED			
MEG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.08		
REV. F	DRAWING NO.	SHEET 6 OF 6	
	D2850		
SCALE	TITLE		
NTS	208/407 SKIDTUBE ASSEMBLIES		

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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 12.10.12	CHECKED A.Q.	DATE 12.10.22	MFG. APPR. [Signature]	APPROVED [Signature]	DE APPR. [Signature]	DATE 12.10.22	

PURPOSE:
CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:
PARTS LIST IS AMENDED AS FOLLOWS:

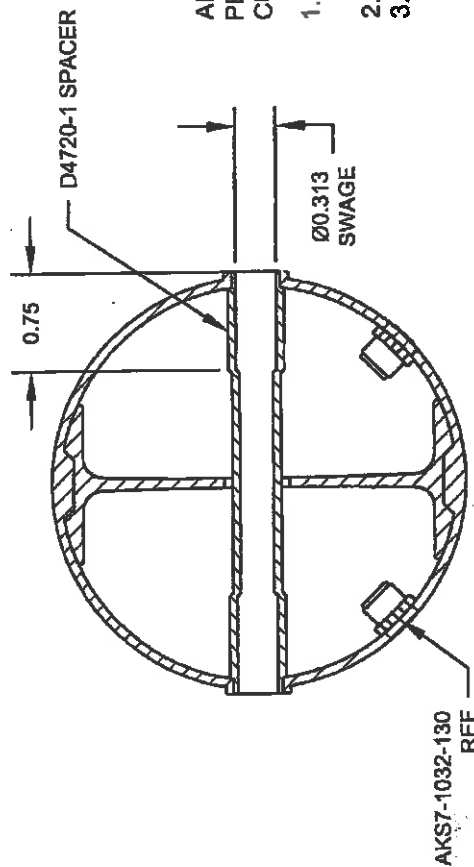
IS:

QTY	QTY	QTY	QTY	DESCRIPTION
-1	-3	-5	-7	
1	1	0	0	D2649
16	17	19	23	D4720-1
				CROSS BOLT SPACER
				SPACER

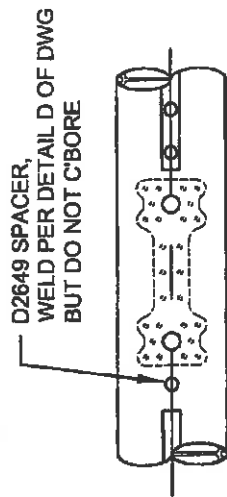
WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
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ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.
C'BORED HOLES ARE NOW SWAGED PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT
C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL G
FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE



DETAIL B
AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002